



PREMIER AVIATION, INC.
 2020 Aviation Parkway, Grand Prairie, Texas 75050
 SIZE: 11x17 DATE: 10/20/64 DWG NO: 867-43001 REV: 01
 SCALE: 1:1

ORIGINAL

Date: Wednesday, 30/07/2008 11:12:21 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 40816

Part Number: PB674300163

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

PB6743001133

Clevis



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

batch: 323994

08-08-26 3

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble by drilling thru both -157 and -133 as per dwg

2- install spring slotted pin as per dwg

08-08-26 3

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/08/26 (x3)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

39952

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26

Job Completion



08/08/26

Date: Wednesday, 30/07/2008 11:12:20 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHORT T-HANDLE ASSY

Job Number: 40816

Part Number: PB674300163

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- chamfer both ends (0.090") on -129 and -127
- 2- chamfer (0.090") only the angle end on -157
- 3- drill #40 hole in center of -129 before welding -131 caps, to let air out
- 4- weld -131 to -129 as per dwg
- 5- grind weld flush
- 6- assemble -127 under the pilot hole in -129 and -157 weld as per dwg
- 7- grind weld flush
- 8- install rivet as per dwg

Handwritten: 08.07.08 3

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Handwritten: 08-08-12 (3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/08/12 (3)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Handwritten: M102316

Handwritten: (3X)

****mask only -157 starting from rivet to end of -157 tube, rivet must be powder coat****
Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Handwritten: 3:30
320 °F
4:00

Handwritten: M.F. 08/08/12

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08-08-13

Handwritten: (3X)

11.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

SPRING SLOTTED PIN

batch:

Handwritten: 7830

Handwritten: 08.08.26

Handwritten: 3

Date: Wednesday, 30/07/2008 11:12:20 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT T-HANDLE ASSY
 Job Number : 40816
 Estimate Number : 13529
 P.O. Number :
 This Issue : 30/07/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : LARGE FAB ASSY
 Previous Run :
 Written By :
 Checked & Approved By : MF 08-08-30
 Comment : Est Rev:A 08-07-29 new issue DD verified by:ec

Part Number : PB674300163
 Drawing Number : B6743001 P.15
 Project Number : N/A
 Drawing Revision : B1
 Material :
 Due Date : 06/08/2008 Qty: 3 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PB6743001131 Tube End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Tube End Cap

batch: 340020

MF 08-01-08 3

2.0 PB6743001129 Tube Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Tube Handle

batch: M10531

MF 08-07-08 3

3.0 PB6743001127 Handle Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Handle Arm

batch: M10531

MF 08-01-08 3

4.0 PB6743001157 Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Tube

batch: M10531

MF 08-01-08 3

5.0 CR321342 Cherry Rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Cherry Rivet

batch: 102569

MF 08-08-12 3